

Work Order ID 65885

Wednesday, January 26, 2011 1:54:51 PM



Page 1

Item ID: D4276-1

Accept



Setup Start



Revision ID:

Item Name: Aft Beam

Stop



Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-01-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4276	A								
100	BAND SAW	0.00							
	Memo Cut Blank to 36.630" Batch: 107221	0.00							
Bandsaw									
Jeaspa Bandsaw									
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	Memo 1-Machine per folio FB007 DWG REV: A FOLIO REV: AA	0.00							
HAAS 1									
HAAS CNC vertical machine #1									
	2- deburr rough edges								

2 11/04/11

(4)

B.A 11/04/12

4

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65885

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Wednesday, January 26, 2011 1:54:52 PM

Item ID: D4276-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Beam

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

J.A 11/04/12

4

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

amr 11/04/13

4

0

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

H BL 11-4-13.

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 65885



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Wednesday, January 26, 2011 1:54:52 PM

Item ID: D4276-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Aft Beam					
Start Date: 1/26/2011	Start Qty: 4.00		Cust Item ID:		
Required Date: 2/4/2011	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>m116964</i> Memo MASK AS PER DWG	0.00 <i>START: 10:30</i> <i>OVEN: T: 300</i> <i>FINISH: 11:00</i>				<i>4</i>	<i>BR</i>	<i>11-4-13</i>	
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>4</i>	<i>d</i>	<i>11-4-13</i>	
180 Packaging Packaging	Identify as per dwg & Stock Location: <i>St 200</i> Memo	0.00 0.00						<i>4</i>	

ES 4/04/14 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 65885

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Wednesday, January 26, 2011 1:54:52 PM

Item ID: D4276-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Beam

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/15

11-04-19

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 1:54:58 PM

Page 1

Work Order ID: 65885



Parent Item: D4276-1



Parent Item Name: Aft Beam

Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B
10.12.02 AS PER DWG REV.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	53.2995	3.052	12.85053			



6061-T6 Bar 1.00 x 4.00



SL 1/10/11

Location	Loc Qty	Loc Code
MAT03	53.2995	
107221	45.2937	
114352	8.0058	

- 12.9

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65885
Description: AFT BEAM		Part Number: D4276-1
Inspection Dwg: D4276 , Rev: A		Page 1 of 2

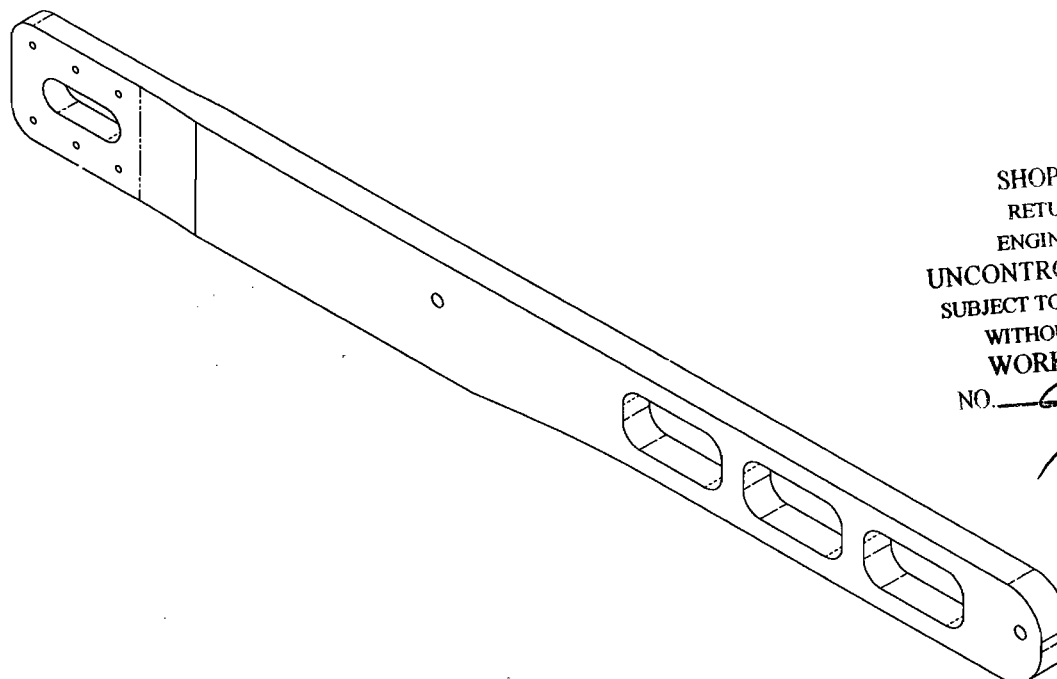
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/- .030	0.750	✓		Vern	GA-01
20.500	+/- .010	20.500	✓		Tape	GA-12
Ø 0.381	+0.000/- .001	0.3810	✓		Mic	GA-03
14.380	+/- .010	14.380	✓		Tape	GA-12
R 0.75	+/- .030	R 0.750	✓		R-6	ref.
3.50	+/- .030	3.503	✓		Vern	GA-01
16.38	+/- .030	16.380	✓		Tape	GA-12
5.00	+/- .030	5.000	✓		Vern	GA-01
0.75	+/- .030	0.751	✓		"	"
2.75	+/- .030	2.750	✓		"	"
3.00	+/- .030	3.003	✓		"	"
1.250	+/- .010	1.252	✓		"	"
4.50	+/- .030	4.500	✓		"	"
0.734	+/- .010	0.733	✓		"	"
0.108	+/- .010	0.104	✓		H-6	31006
36.38	+/- .030	36.380	✓		Tape	GA-12
0.95	+/- .030	0.946	✓		Vern	GA-01
0.60	+/- .030	0.597	✓		"	"
2.70	+/- .030	2.698	✓		"	"
1.10	+/- .030	1.100	✓		"	"
1.25	+/- .030	1.249	✓		"	"
0.75	+/- .030	0.752	✓		"	"
3.000	+/- .010	3.000	✓		"	"

Measured by: B.A	Audited by: <i>anf</i>	Prototype Approval:
Date: 11/04/12	Date: 11/04/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4276-1 AFT BEAM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65885

2011-01-26

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.68 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

RELEASE
2010-11-30

A		NEW ISSUE		SC	10.11.25
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	JPH				
CHECKED	#	DRAWING NO.	SHEET 1 OF 2		
MFG. APPR.	#	D4276	SCALE		
APPROVED	#	TITLE	NTS		
DE APPR.	#	AFT BEAM	NTS		
DATE		10.11.25			
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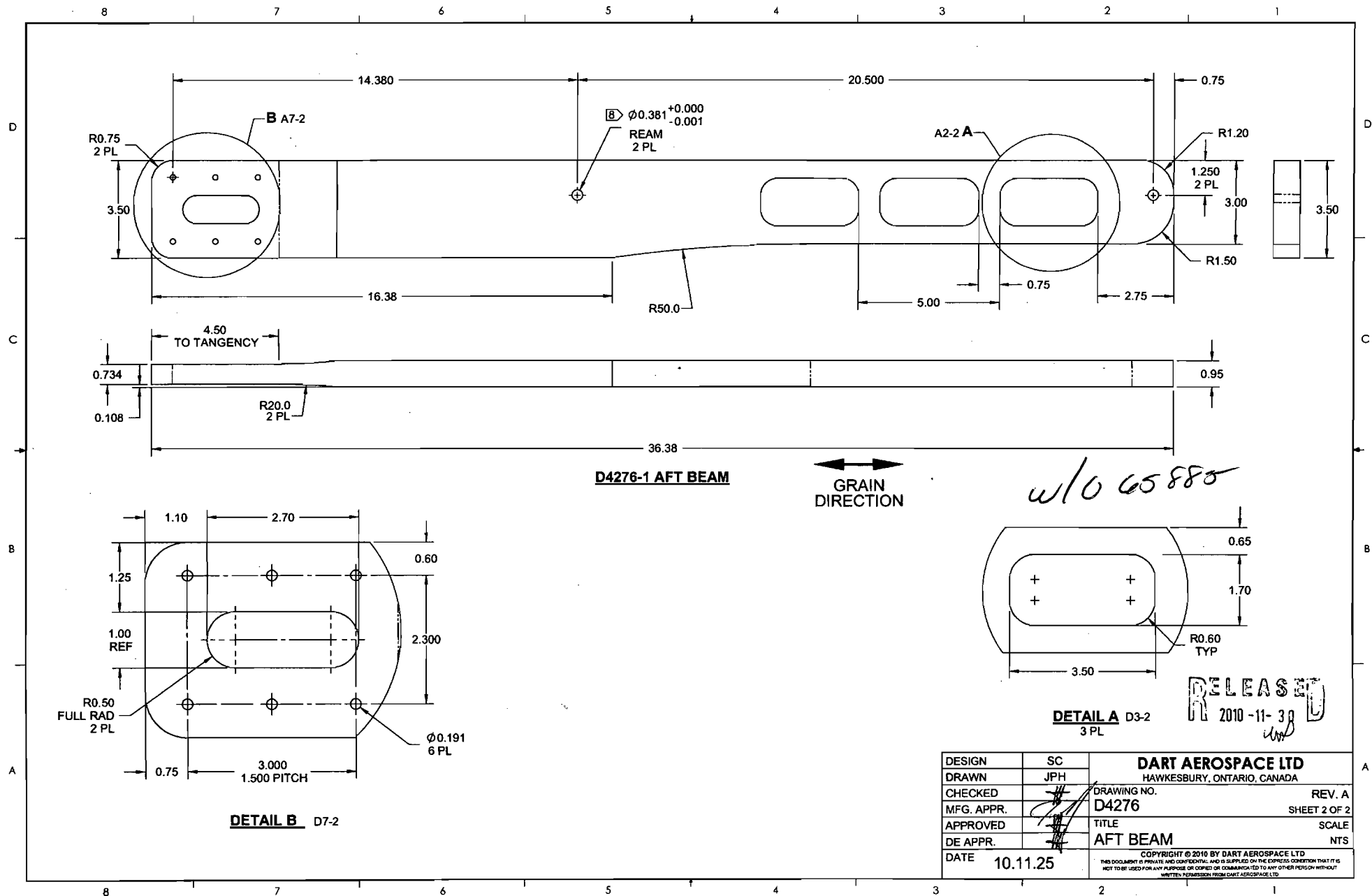
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